

Work Order ID 110533

December-24-13 7:00:24 AM

110533

U/R

Page 1

Item ID: D4464-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fuel Tank Assembly
 Start Date: 12/24/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 1/03/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4464	Rev. D PEI <u>12/24/13</u>								
100	Weld per dwg A/R Aluminum rod Batch: <u>125127</u> <u>124805</u>	0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1- Weld D4023-3 cap, and D4008-11 hinge onto D4463-11 as per dwg D4464								<u>14-02-10</u>
110	QC9- Inspect visual per QS1004- Fusion Welds	0.00							
110									
QC	Memo	0.00							<u>14-02-10</u>
Quality Control									

Achtung!
 Vor Einbau Sicherungstift herausnehmen
 Attention,
 remove safety pin before installation
 Atenção!
 Remova o pino de segurança antes de montar

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Item ID: D4464-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fuel Tank Assembly

Start Date: 12/24/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
112		0.00							
112									
Small Fab									
Small Fab									
	Memo	0.00							
	1- Transfer drill holes from hinge to tank side as per dwg deburr and touch up with alodine								
	2- Install hinge wet with proseal as per dwg A/R Proseal Batch: _____								
	3- To match drill front and back panel to baffles, cleko them together and open holes to size.								
	4- Disassemble panels for deburring and touch up chemical conversion coat.								
	5- Wet install baffles to front and back panel using rivet and Proseal as per dwg A/R Proseal Batch: _____								
114	QC5- Inspect part completeness to step on W/O	0.00							
114									
QC	Memo	0.00							
Quality Control									

N/A.
BAFFLES
NOT RIVETED
on THIS TANK.
11/14/02/11

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 Required Date: 1/03/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Weld per dwg A/R Aluminum rod Batch: 125127 127865	0.00				1	φ		14.02.11
120									
Large Fab	Memo	0.00							
Large Fab	1- Weld D4001-1 and D4000-5 onto D4463-1 Top								
	2- Weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047								
	3- Weld D4000-043 and D4000-045 on tank as per dwg.								
	4- Instal D4000-9 grommets as per dwg, Weld D4463-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg								
	5-Weld D4463-7 fwd end								
	PURGE INSIDE OF TANK	14.02.11							
	6-Weld top D4463-1 using DT9811 and DT9810								
	PURGE INSIDE OF TANK	14.02.11							

PTO

NO PTO

PURGING OVERLOOKED
 DUE TO ROSSMITH, 14.02.11
 TANK WAS NOT PURGED BEFORE.

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Item ID: D4464-041 Accept ***N900040100*** Setup Start ***NS1***
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 Required Date: 1/03/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
123 *123* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo ***Pressure Test as per dwg D4464***	0.00 0.00				<u>1</u>			<u>M/W 14-02-12</u>
140 *140* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				<u>1</u>	<u>14-02-11</u>		<u>DAS 9 9-89</u>
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo 1- brush alodine on tank. No alodine inside	0.00 0.00				<u>1</u>	<u>76</u>	<u>14-2-13</u>	

DQA:

Date: 14/02/28



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 14-2-21

Work Order update only ☐

Work Order: <u>110533</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>04464-041</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>14-3552</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
	Large Fab <input checked="" type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	14.02.18	120	1	NO TABS ZONE (C5-4) FOR GROUNDING REQUIRED.	A.P. 14.02.18	DO NOT ADD TABS	A.P. 14.02.18	DAS 27 9-89 14/2/20	DAS 27 9-89 14/2/20
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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DQA: Aut Date: 14/02/28

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: OK Date: 14/2/28Work Order update only ☐

Work Order: <u>110533</u>	DISPOSITION Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D4464-04</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>14-3582</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input checked="" type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design				had to change 1 lock nut Plate	DAS 16 9-89	Change removed + change locknut Plate + rivet	<u>D</u> 14/02/13	<u>Shir</u> 14/2/18	DAS 16 9-89
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material	14/02/13	160	1	M 1127813	AS7042 (14/2/13)				AS7042
Operator				2 rivet					14/02/13
Offset/Setup				MS 2042 AD 3-Y					
Process				M 125578					
Supplier				because I was					
Training				defect					
Transport									
Unapproved				Re Defect Handover.					

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Item ID: D4464-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fuel Tank Assembly
 Start Date: 12/24/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/03/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC7-Inspect Chemical Conversion Coat	0.00		DAS 30 989		1			14/02/13
160									
QC	Memo	0.00							
Quality Control									
160	QC7-Inspect Chemical Conversion Coat	0.00		DAS 30 989		1			14/02/13
160									
QC	Memo	0.00							
Quality Control									
170	QC7-Inspect Chemical Conversion Coat	0.00		DAS 30 989		1			14/02/13
170									
Powdercoat	Memo	0.00							
Powder Coating	***Mask prior to powdercoat***								
	POWDER COAT ANSI 61 GREY AS PER DWG AND OSI 005 4.3								
	Start Time: _____								
	Oven Temperature: _____								
	Finish Time: _____								
180	QC7-Inspect Part Finish	0.00		DAS 27 989		1			14/02/13
180									
QC	Memo	0.00							
Quality Control									

160 Small fab
 14/02/13
 170
 14/02/13
 Powdercoat
 Powder Coating
 Spray paint

Apply Primer on all nut plate & around top panel
 to seal TOP H 127662
 QCS
 Mask prior to powdercoat
 POWDER COAT ANSI 61 GREY AS PER DWG AND OSI 005 4.3
 Start Time: _____
 Oven Temperature: _____
 Finish Time: _____
 primer 126558
 paint 1127810

14/02/13
 14/02/13
 14/02/13
 14/02/13

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Item ID: D4464-041 Accept *N900040100* Setup Start *NS1*
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 Start Date: 12/24/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 1/03/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
190		0.00								
190										
Small Fab										
Small Fab										
	Memo	0.00								
	1- Mask off area, where access cover is applied									
	2- Abrade surface with red scotch brite									
	3- Wipe with clean cloth and wash and wipe									
	4- Assemble as per dwg and for D4577-041/-3/-5 access panels install wet with proseal 890									
	A/R Proseal 890 Batch: _____									
	5- Install cushion using contact cement									
	A/R Contact Cement Batch: <u>M627443</u>									
200	QC5- Inspect part completeness to step on W/O	0.00								
200										
QC										
Quality Control										

DAS
36
9-89

DAS
27
9-89

4/2/00

14/02/20

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Work Order ID: 110533

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 12/24/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.11.23 NEW ISSUE DD VERF:EC IPP REV:B 12.03.08 AS PER
DWG REV.B DD VERF:EC IPP REV:C 12.04.24 ECN 12-571 DD VERF:EC
IPP REV:D 13.10.30 DWG REV PE1 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-6A Bolt		Purchased	No			190	Each	271.0000	4	4	DAS 28 9-89	14-02-19	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST511		271							
				M127044		271				4x			
D4968-1 Side Cushion		Manufactured	No			190	Each	1.0000	1	1	DAS 28 9-89		
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				prelim		1							
				110413		1				1x			
MS20470AD4-5 RIVET, UNIVERSAL HEAD		Purchased	No			112	Each	2,127.0000	165	165	DAS 28 9-89		
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		451							
				m126926		451							
				ST336		1676							
				m126926		1676				165x - 165			
NAS1149D0332J Washer		Purchased	No			190	Each	2,160.0000	5	5	DAS 28 9-89		
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST293		726							
				m127431		726							
				ST294		44							
				m125807		44							
				ST510a		1390							
				m127374		390							
				m127389		1000				5x			

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Work Order ID: 110533
 Parent Item: D4464-041
 Parent Item Name: Fuel Tank Assembly

Start Date: 12/24/13 Required Date: 1/03/14
 Start Qty: 1.00 Required Qty: 1.00

D3997-5	Manufactured	No	190	Each	69.0000	2	2	DAS 28 9-89	14-02-19
Placard									
			<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>	
			ST244A		69				
			72611		69		2x		
D3997-11	Manufactured	No	190	Each	27.0000	1	1	DAS 28 9-89	
Placard									
			<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>	
			ST244A		27				
			106884		12				
			107679		10		1x		
			99791		5				
D3997-17	Manufactured	No	190	Each	25.0000	1	1	DAS 28 9-89	
Placard									
			<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>	
			ST244A		25				
			100181		7				
			106785		8				
			107632		10		1x		
D3997-29	Manufactured	No	190	Each	17.0000	1	1	DAS 28 9-89	
Placard									
			<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>	
			ST244A		17				
			100182		5		1x		
			106864		12				
D3997-43	Manufactured	No	190	Each	27.0000	1	1	DAS 28 9-89	
Placard									
			<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>	
			ST244A		27				
			100183		5				
			106642		12		1x		
			107558		9				
			82960		1				

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Work Order ID: 110533
Parent Item: D4464-041
Parent Item Name: Fuel Tank Assembly

Start Date: 12/24/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D3999-7 Corner Manufactured No 120 Each 20.0000 1 1 12/14/02/10

Location Loc Qty Loc Code

WA003 20

108621 20

D3999-9 Angle Manufactured No 112 Each 8.0000 1 1 12/14/02/10

Location Loc Qty Loc Code

WA003 8

109025 8

D4000-1 Fuel Supply Fitting Manufactured No 120 Each 24.0000 1 1 12/14/02/10

Location Loc Qty Loc Code

WA003 24

105046 8

106818 10

107304 6

D4000-5 Fuel Tank Vent Fitting Manufactured No 120 Each 21.0000 1 1 12/14/02/10

Location Loc Qty Loc Code

WA003 21

100528 6

106917 9

107388 6

D4000-9 Grommet Manufactured No 120 Each 63.0000 3 3 12/14/02/10

Location Loc Qty Loc Code

WA003 63

105466 25

106808 38

D3999-11

B 100184

3
1
12/14/02/10

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Start Date: 12/24/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D4000-045	Manufactured	No	120	Each	10.0000	1	1	
Fuel Pickup Fitting Assembly								14-02-10

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Parent Item: D4464-041

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Start Date: 12/24/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D4057-1 Manufactured No 120 Each 103.0000 3 3 14.02.10
Retaining Ring

Location	Loc Qty	Loc Code
WA003	103	
102453	2	
106766	51	
107269	50	

D4062-041 Manufactured No 190 Each 15.0000 1 1 14.02.11
Tank Support Assembly

Location	Loc Qty	Loc Code
WA003	15	
100076	5	
106669	1	
107170	5	
90627	4	

D4124-1 Manufactured No 120 Each 44.0000 4 4 14.02.11
Tab

Location	Loc Qty	Loc Code
WA003	44	
100079	19	
106845	5	
107333	20	

D4125-1 Manufactured No 120 Each 5.0000 1 1 14.01.14
Sump

Location	Loc Qty	Loc Code
WA003	5	
107267	3	
99890	2	

D4125-3 Manufactured No 120 Each 6.0000 1 1 14.01.14
End

Location	Loc Qty	Loc Code
WA003	6	
106826	4	
99891	2	

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Start Date: 12/24/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D4404-3 Manufactured No 120 Each 2.0000

Cushion, Side

1 1 DAS 28 9-89 14-02-19

Location B 111321 Loc Qty Loc Code

ST144 2

~~100080~~ 2

D4404-5 Manufactured No 120 Each 9.0000

Cushion, Fwd

4 4 DAS 28 9-89

Location Loc Qty Loc Code

ST145 9

102143 7

99743 2

D4462-1 Manufactured No 112 Each 5.0000

Baffle

1 1 14-02-11

Location Loc Qty Loc Code

prelim B106871 4

108664 2

108971 2

WA003 1

100191 1

D4462-3 Manufactured No 112 Each 7.0000

Baffle

1 1 14-02-11

Location Loc Qty Loc Code

prelim 2

108665 1

108972 1

WA003 5

100075 5

D4463-041 Manufactured No 120 Each 3.0000

Tank Top Assembly

1 1 14-02-10

Location Loc Qty Loc Code

WA003 3

107163 3

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Work Order ID: 110533
 Parent Item: D4464-041
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Start Date: 12/24/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D4463-3 Manufactured No 120 Each 3.0000
 Tank Aft End

1 1 1214.02.10

Location Loc Qty Loc Code

WA003 3
 105123 3

D4463-5 Manufactured No 120 Each 0.0000
 Tank Upper Cut Out

1 1 1214.02.10

D4463-7 Manufactured No 120 Each 3.0000
 Tank Fwd End

1 1 1214.02.10

Location Loc Qty Loc Code

WA003 3
 106914 3

D4463-9 Manufactured No 112 Each 4.0000
 Tank Back

1 1 1214.02.10

Location Loc Qty Loc Code

prelim 1
 108666 1
 WA003 3
 106918 3

D4463-11 Manufactured No 112 Each 4.0000
 Tank Front

1 1 1214.02.07

Location Loc Qty Loc Code

WA003 B107380 4
 106908 2
 108667 2

D4463-13 Manufactured No 190 Each 1.0000
 Tank Bottom

1 1 1214.01.14

Location Loc Qty Loc Code

WA003 1
 106906 1

December-24-13 7:00:23 AM

Shop Packet Print

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Picklist Print

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Work Order ID: 110533
Parent Item: D4464-041
Parent Item Name: Fuel Tank Assembly

Start Date: 12/24/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

AN3H5A Bolt	Purchased	No	190	Each	103.0000	5	5	DAS 28 9-89	14-02-19
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST350	103					
			124805	3					
			125445	50		5X			
			m127044	50					
MS21042L3 Nut	Purchased	No	190	Each	5,378.0000	4	4	DAS 28 9-89	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST506	962		127355			
			123900	962					
			ST509	4000					
			M127304	1000					
			M127410	3000		4X			
			ST510a	416					
			M126333	416					
NAS1149D0363J Washer	Purchased	No	190	Each	2,713.0000	32	32	DAS 30 9-89	14/02/13
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			GA	170					
			124392	170		31			
			ST510a	2543					
			m126319	2543		32			
AN3-4A Bolt	Purchased	No	190	Each	482.0000	24	24	DAS 30 9-89	14/02/13
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST511	482		M 117423 24			
			m127044	482		24			

December-24-13 7:00:23 AM

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Page 8

Picklist Print

December-24-13 7:00:23 AM

Page 9

Work Order ID: 110533

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 12/24/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D4577-1
Rear Access Panel

Manufactured No

190 Each 2.0000

1 1

DAS
30
9-89

14/02/13

Location

Loc Qty

Loc Code

ST142
107395

2
2

1
1

DAS
30
9-89

14/02/13

D4577-3
Middle Access Panel

Manufactured No

190 Each 4.0000

1 1

Location

Loc Qty

Loc Code

ST142
107197

4
4

1
1

DAS
30
9-89

14/02/13

D4577-041
Fwd Access Panel Assembly

Manufactured No

190 Each 1.0000

1 1

Location

Loc Qty

Loc Code

ST142
107207

1
1

1
1

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4464-041	FUEL TANK ASSEMBLY
2	2	D3997-5	PLACARD "AUX FUEL DRAIN"
3	1	D3997-11	PLACARD "LOADING"
4	1	D3997-17	PLACARD "STOWAGE"
5	1	D3997-29	PLACARD "WARNING"
6	1	D3997-43	PLACARD "EARTH"
7	1	D3999-7	CORNER
8	1	D3999-9	ANGLE
9	1	D3999-11	EARTH TAB
10	1	D4000-1	FUEL SUPPLY FITTING
11	1	D4000-5	FUEL TANK VENT FITTING
12	3	D4000-9	GROMMET
13	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
14	1	D4008-11	TANK HINGE HALF
15	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
16	1	D4023-3	FUEL CAP
17	1	D4025-5	FUEL SENDER
18	3	D4057-1	RETAINING RING
19	1	D4062-041	TANK SUPPORT ASSEMBLY
20	4	D4124-1	TAB
21	1	D4125-1	FWD SEDIMENT BOWL
22	1	D4125-3	AFT SEDIMENT BOWL
23	1	D4404-3	CUSHION, SIDE
24	4	D4404-5	CUSHION, FWD
25	1	D4462-1	BAFFLE
26	1	D4462-3	BAFFLE
27	1	D4463-041	TOP TANK ASSEMBLY
28	1	D4463-3	TANK AFT END
29	1	D4463-5	TANK UPPER CUT OUT
30	1	D4463-7	TANK FORWARD END
31	1	D4463-9	TANK BACK
32	1	D4463-11	TANK FRONT
33	1	D4463-13	TANK BOTTOM
34	1	D4577-041	FWD ACCESS PANEL ASSEMBLY
35	1	D4577-1	REAR ACCESS PANEL
36	1	D4577-3	MIDDLE ACCESS PANEL
37	24	AN3-4A	BOLT
38	5	AN3H5A	BOLT
39	4	MS21042L3	NUT
40	4	MS35207-266	SCREW
41	37	NAS1149D0363J	WASHER

UNDER REVIEW

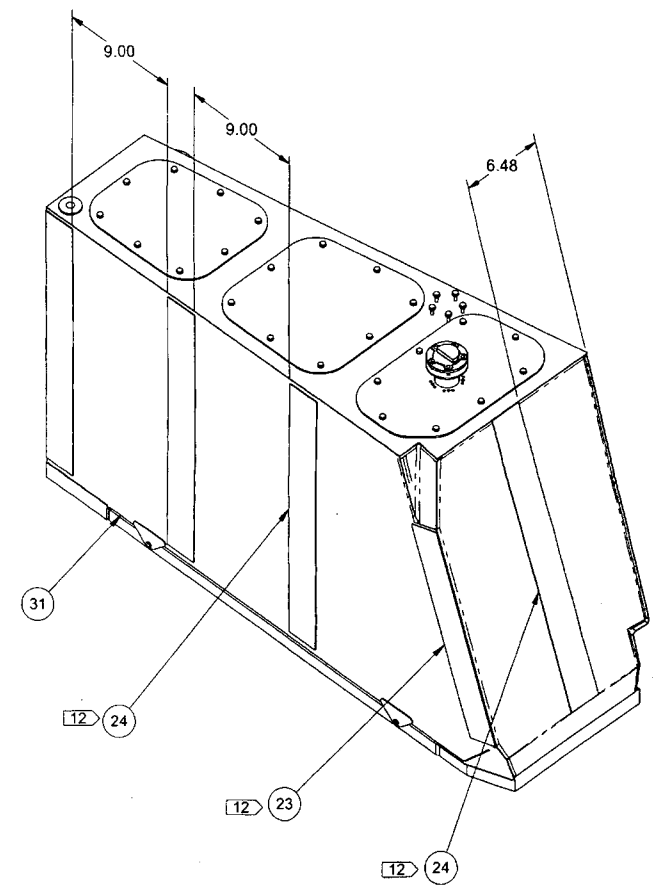
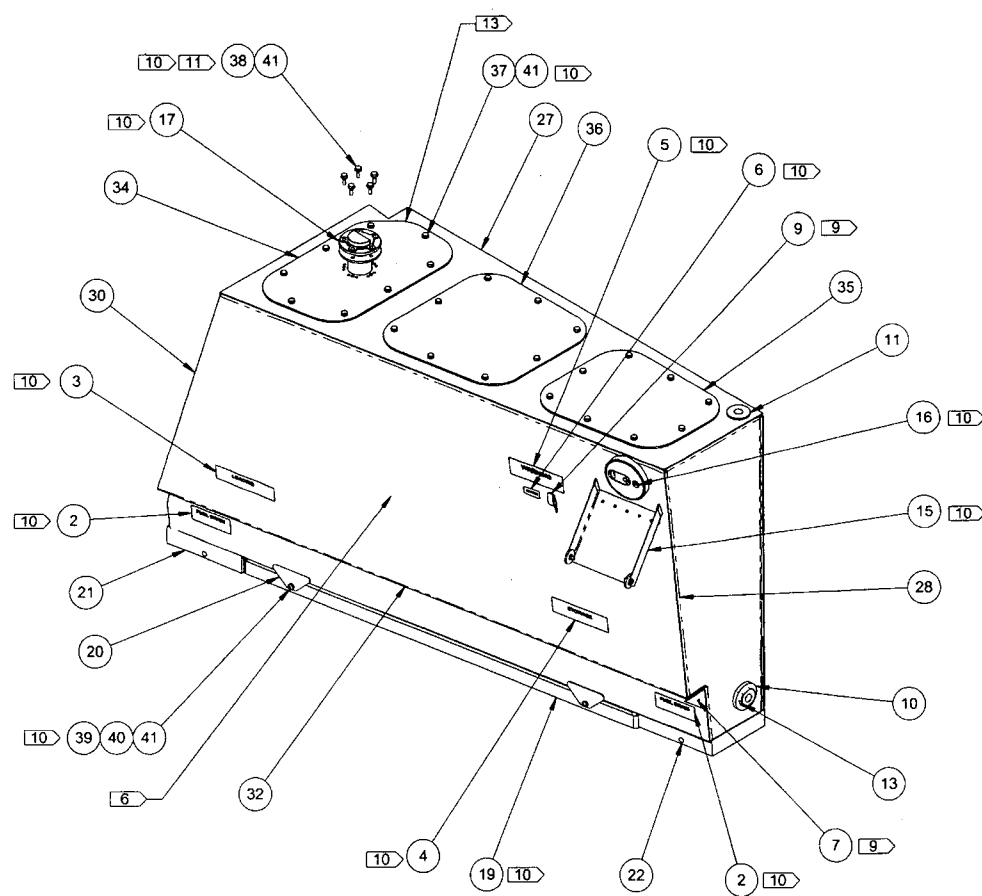
13.10.11 *me*
CHANGING BATTLE DESIGN

RELEASED
2012-05-09
W

W/O 110533

D	ADDED NOTE RE HAND FORMING D4124-1, ZN A8-4.	DC	12.05.02
C	UPDATED -041 WITH RE-DESIGNED D4463-11-13 REV C PARTS, ZN B6-2, UPDATED -041 WITH RE-DESIGNED D4577-041-3/-5 PARTS, ZN C8-2.	DC	12.03.27
B	UPDATED -041 WITH RE-DESIGNED PARTS, REMOVED D4463-13, ADDED D4577-041-1/-5 ACCESS PANELS, ZN C8-2.	DC	11.12.14
A	NEW ISSUE, REF PAR11-117 & CAR 11-54.	DC	11.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>BC</i>		
CHECKED	<i>BC</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>BC</i>	D4464	SHEET 1 OF 5
APPROVED	<i>W</i>	TITLE	SCALE
DE APPR.	<i>W</i>	TANK ASSEMBLY	NTS
DATE	12.05.02	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1



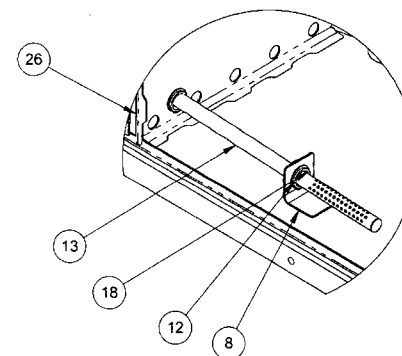
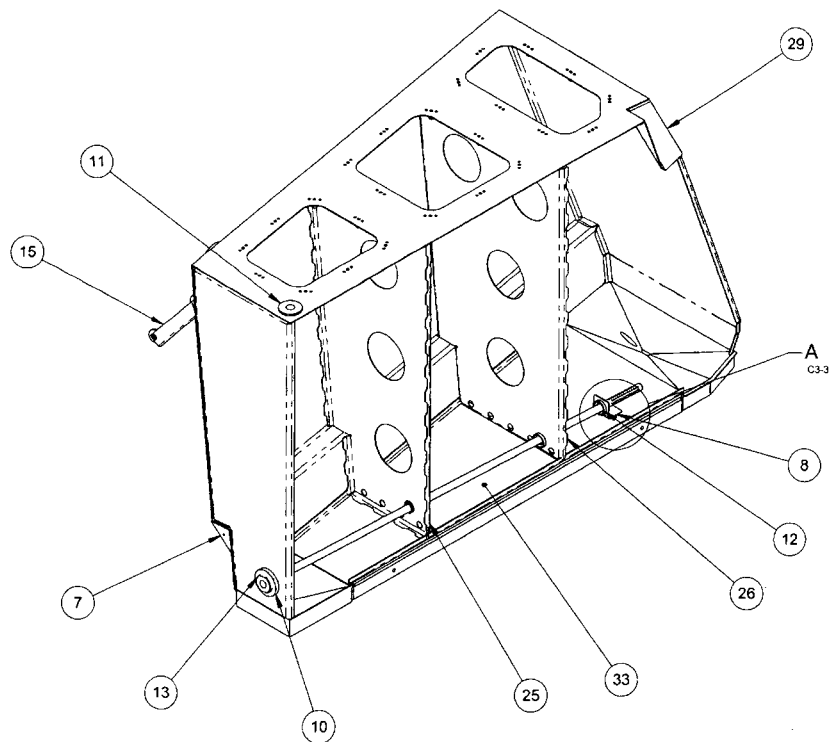
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: TOUCH UP, CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-141" USING D2729-1 RED DECAL
 - 7) WEIGHT: 35.81 lbs
 - 8) CAP ALL TANK ACCESS POINTS AND PRESSURE TEST TANK PER QSI 038 4.3. VERIFY NO LEAKS
 - 9) MASK PRIOR TO POWDER COAT
 - 10) INSTALL AFTER POWDER COAT
 - 11) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
 - 12) INSTALL CUSHIONS AFTER POWDER COAT USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED
 - 13) INSTALL D4577-041/-3/-5 ACCESS PANELS WET WITH PROSEAL 890.

D4464-041 FUEL TANK ASSEMBLY

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2012-05-09

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CHECKED	BC	DRAWING NO.	REV. D
MFG. APPR.	BC	D4464	SHEET 2 OF 5
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	TANK ASSEMBLY	NTS
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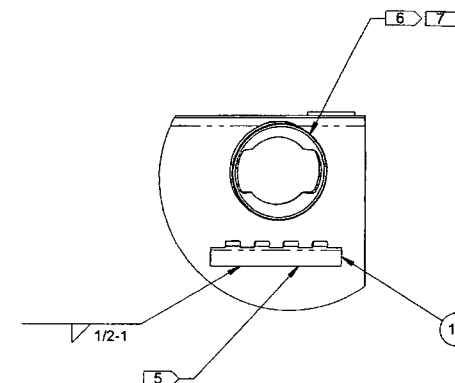
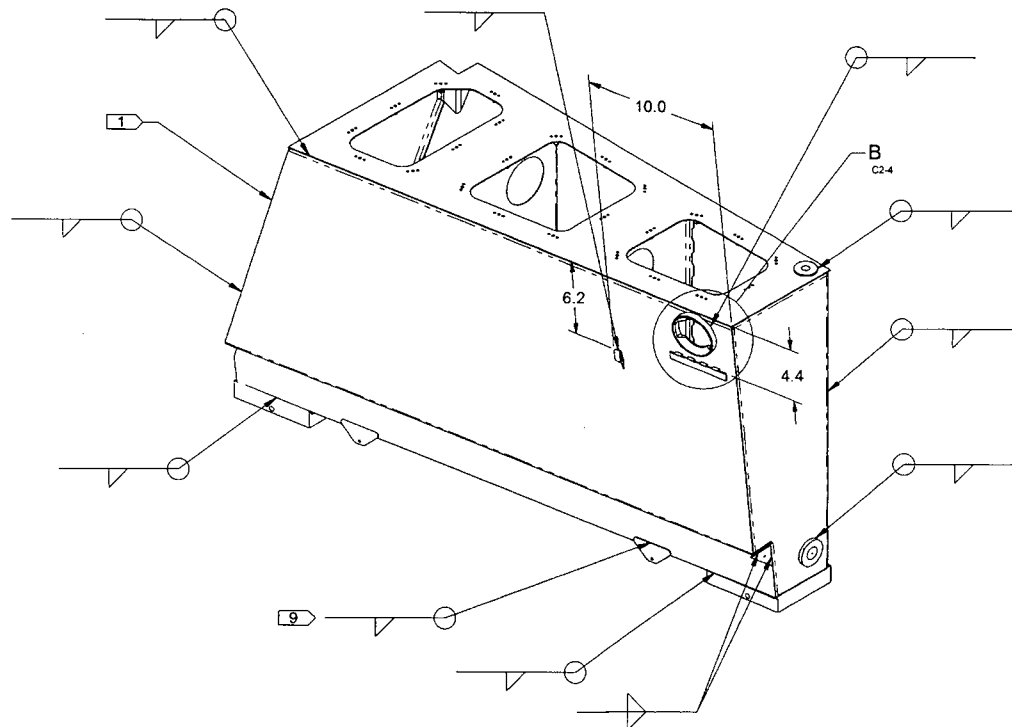
DETAIL A
ROTATED FOR CLARITY
SCALE 2X

B6-3

RELEASED
2012-05-09
W

D4464-041 FUEL TANK ASSEMBLY
D4463-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL

DESIGN	<i>BC</i>	DART AEROSPACE LTD	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>BC</i>	D4464	SHEET 3 OF 5
APPROVED	<i>BC</i>	TITLE	SCALE
DE APPR.	<i>W</i>	TANK ASSEMBLY	NTS
DATE	12.05.02	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



DETAIL B
ROTATED FOR CLARITY
SCALE 2X

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2012-05-09

D4464-041 FUEL TANK ASSEMBLY
WELDING DETAIL

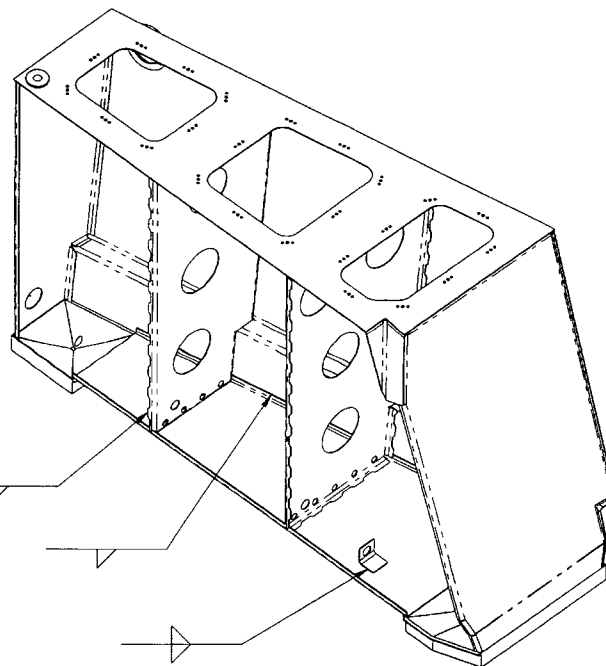
NOTES:

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED
 - END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
 - ALL SWarf REMOVED
- 3) ACCEPTABLE TO DRILL 6 (TYP) $\varnothing 0.312$ HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 4) ACCEPTABLE TO DRILL 7 (TYP) $\varnothing 0.312$ HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) CENTER HINGE BELOW FUEL CAP FLANGE
- 6) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 7) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK
- 8) WELD PER DART QSI 004
- 9) USE THE D4062-041 TANK SUPPORT ASSEMBLY TO POSITION THE D4124-1 TABS BEFORE WELDING;
D4124-1 TABS MAY BE HAND FORMED AS REQUIRED TO FIT D4062-041 ASSEMBLY BEFORE WELDING.



DESIGN		DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. D
MFG. APPR.	BC	D4464	SHEET 4 OF 5
DE APPR.	BC	TITLE	SCALE
DATE	12.05.02	TANK ASSEMBLY	NTS
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WELD ALL TABS



**D4464-041 FUEL TANK ASSEMBLY
WELDING DETAIL**

RELEASED
2012-05-09
JAH

DESIGN	JS	DART AEROSPACE LTD	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. D
MFG. APPR.	JS	D4464	SHEET 5 OF 5
APPROVED	MA	TITLE	SCALE
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